

Work Order ID 52982

October 20, 2009 11:50:43 AM



ASAP

Page 1

Item ID: D3954-5

Accept



Setup Start



Revision ID: A/B

Item Name: Chain Lug

Stop



Start Date: 10/21/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/23/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 09-10-20 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00



Mill Conv

Memo
mill to size

W/VS

0.00

Conventional Milling Machine

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3954

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary



HB 9-10-23

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Setup Start



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Start Date: 10/21/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/23/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

9-10-23

125



0.00

Mill Conv

Memo

0.00

Conventional Milling Machine

Mill as per Dwg

SA 09/10/25

5 4

130



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

27 8 02/10/27

25

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3954-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Chain Lug

Start Date: 10/21/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 10/23/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: 135

0.00



Packaging

Memo

0.00

Packaging

09/14/27 (5)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/29 JF

mf 09-10-27

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Picklist Print

October 20, 2009 11:50:43 AM

Page 1

Work Order ID: 52982



Parent Item: D3954-5RevA



Parent Item Name: Chain Lug

Start Date: 10/21/2009

Required Date: 10/23/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010B1.000X02.000		Purchased	No			100	f	9.0600	2.6316			
1010-1025 Steel Bar 1.00 x 2.00												

10-10-23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	9.06	
107436	9.06	
110368		

110368

M1010B1.000X02.000

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DART AEROSPACE LTD		Work Order: 52982
Description: Chain Lug		Part Number: D3954-5
Inspection Dwg: D3954	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	.88	/			
6.00	+/-0.030	5.996	/			
1.50	+/-0.030	1.501	/			
5.250	+/-0.010	5.249	/			
3.25	+/-0.030	3.251	/			
2.63	+/-0.030	2.636	/			
1.06	+/-0.030	1.062	/			
0.385	+0.025/-0.000	.387	/			
0.31	+/-0.030	.311	/			
0.25	+/-0.030	.257	/			
<hr/>						
Conu. Milling						
Ø.375	±.006	Ø.377	/			
R.185	±.010	R.187	/			
.370	±.010	.375	/			
.12	±.030	.125	/			
.750	±.010	.750	/			
.438	±.010	.440	/			
.88	±.030	.88	/			

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A	
Date: 9/10/03 / 09/10/05	Date: 02/10/07	Date:	N/A	
Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ [Signature]	[Signature]

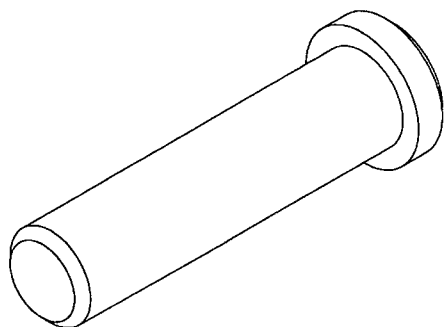
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

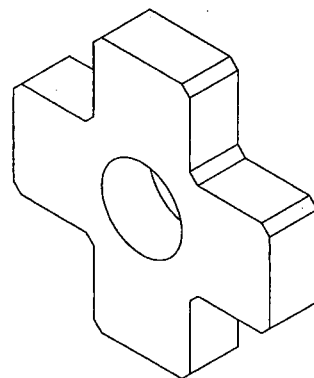
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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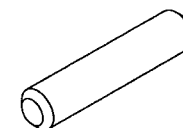


D3954-1 GWT PIN

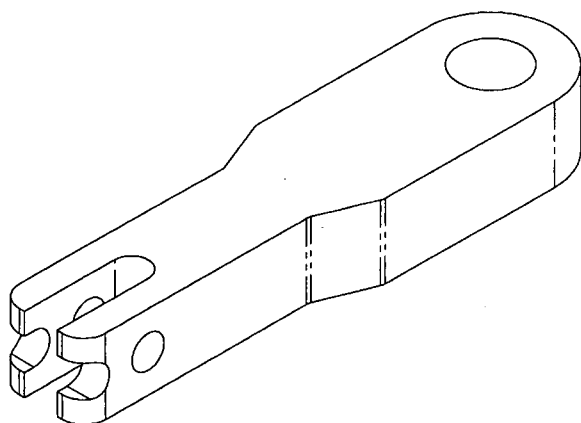


D3954-3 GWT KNOB

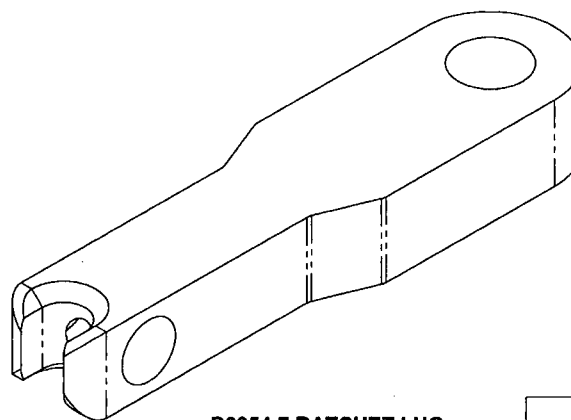
#52982



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

RELEASED
2009-10-19
MP

B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.		AJS	09.10.15
A	NEW ISSUE		AJS	09.05.26
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS	DRAWING NO.	REV. B	
CHECKED		D3954	SHEET 1 OF 3	
MFG. APPR.		TITLE	SCALE	
APPROVED		MISC MACHINED PARTS GWT KIT	NTS	
DE APPR.	N/A	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	09.10.15			

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